

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>MP</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02
MP

u/056497

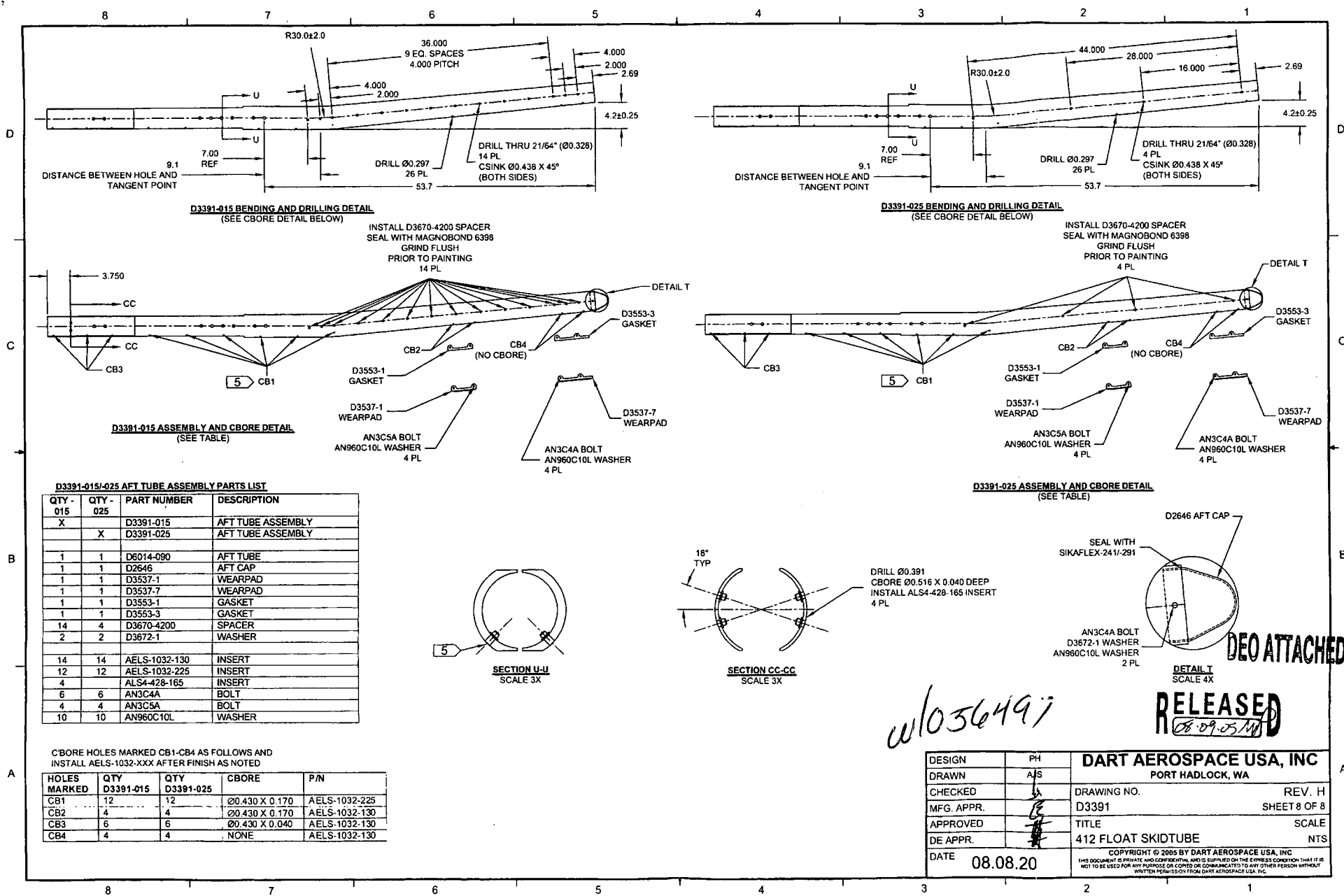
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



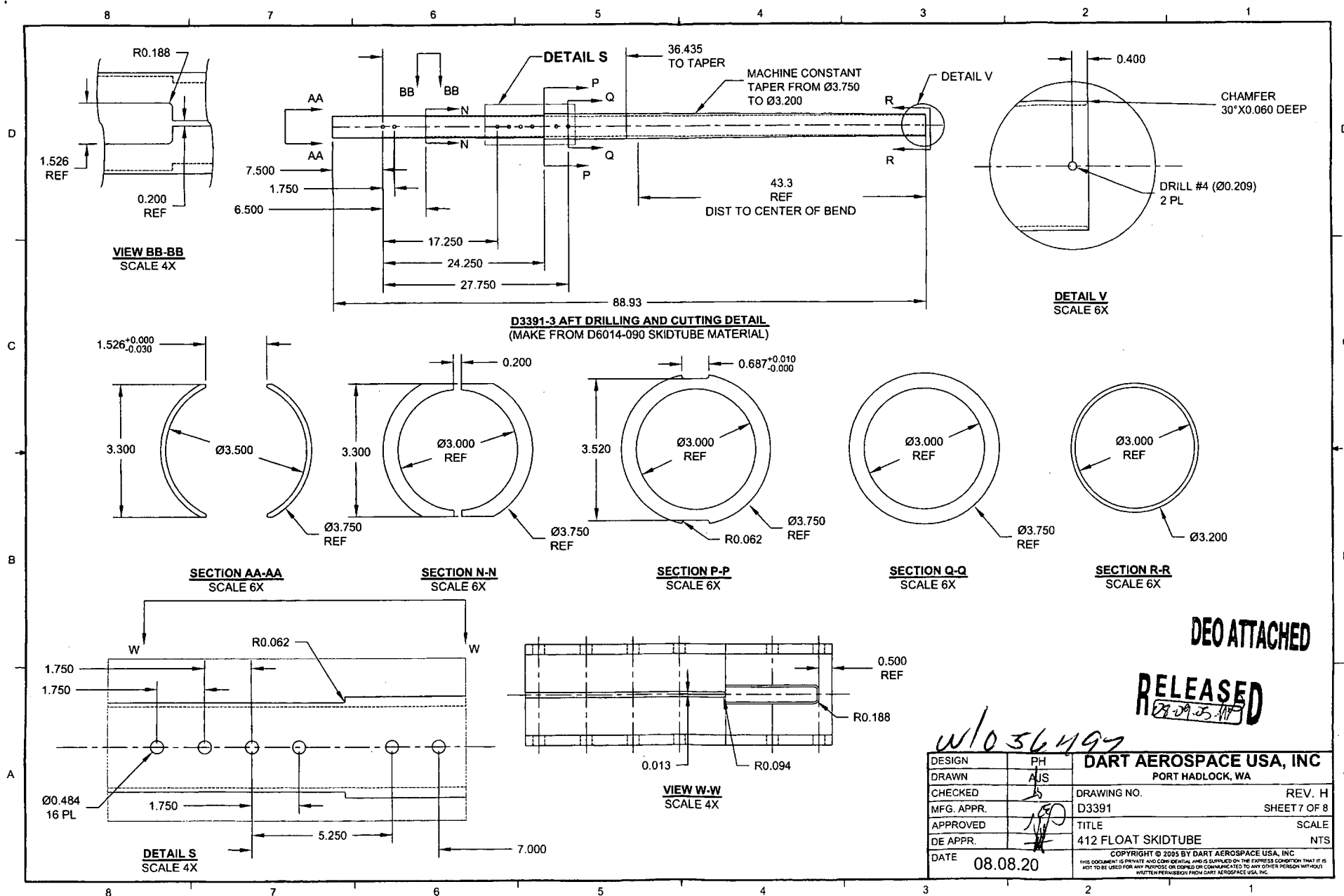
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



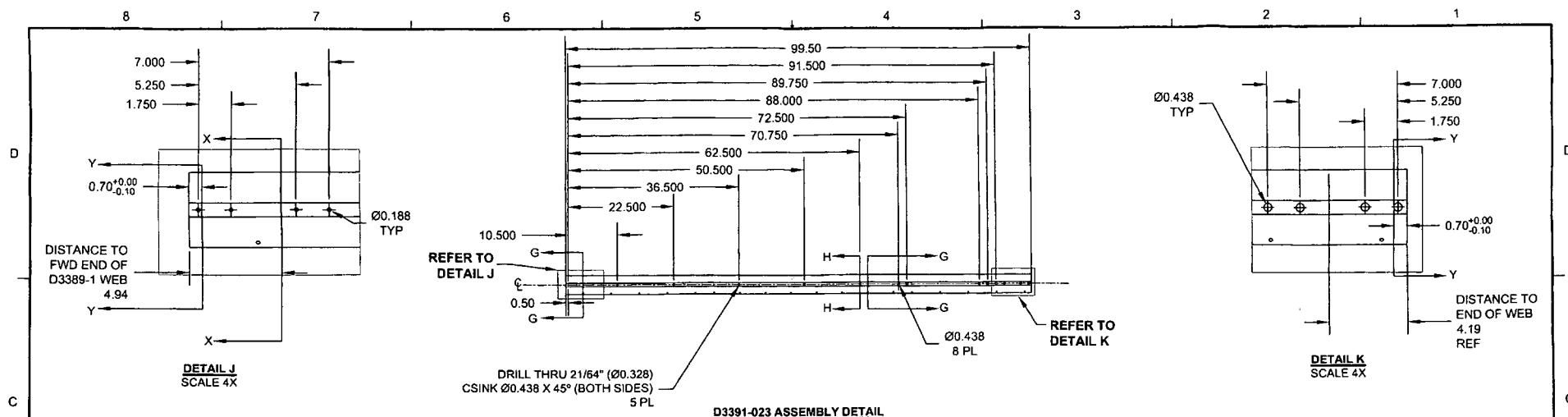
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

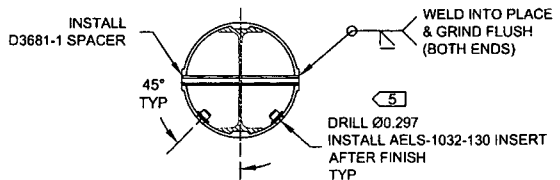
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

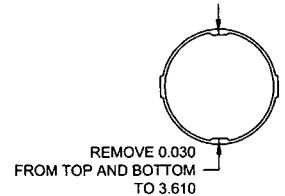
NOTE: Date & initial all entries



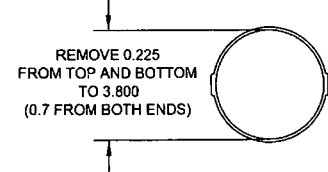
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DEO ATTACHED

RELEASED

W/0 56497

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

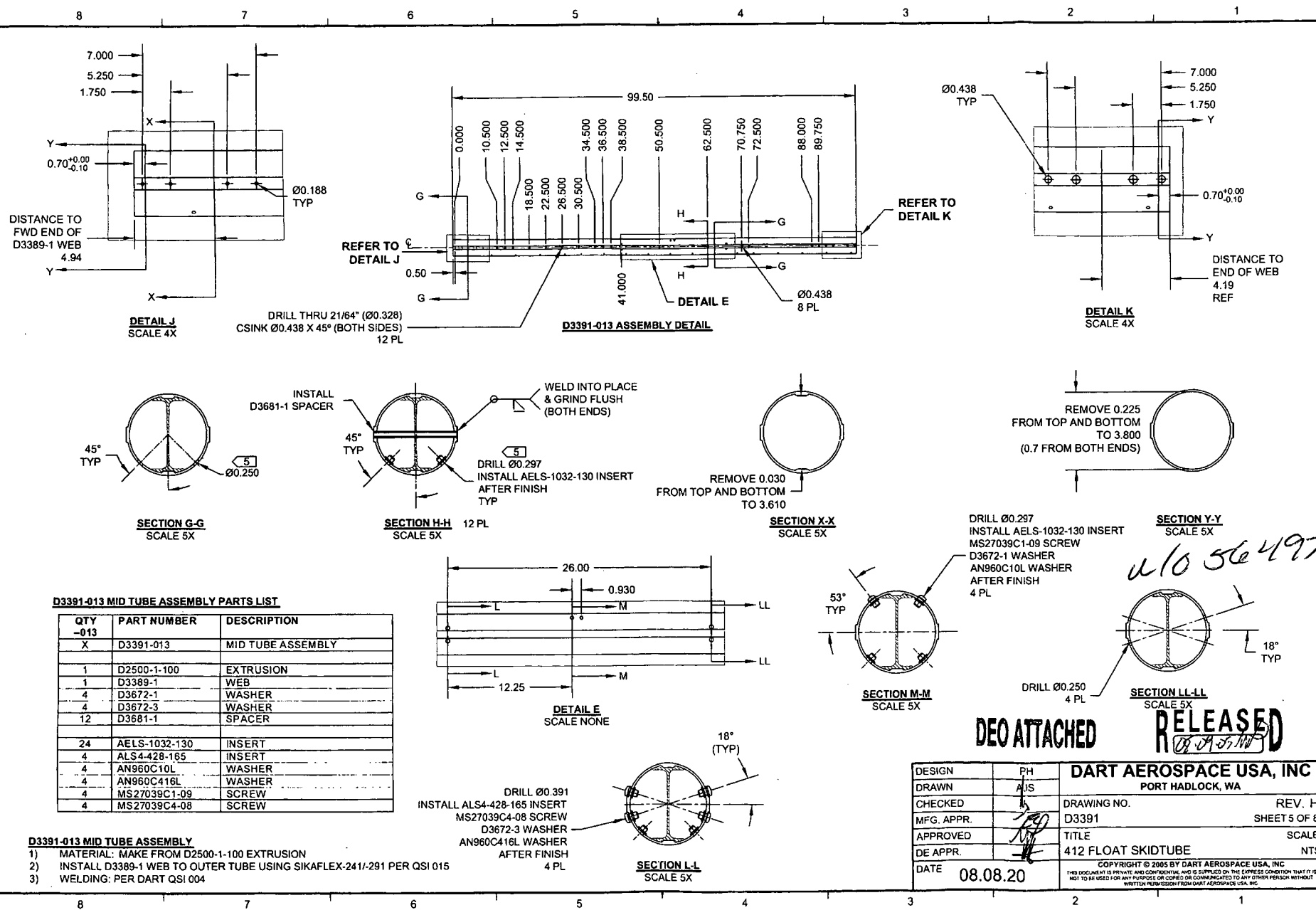
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



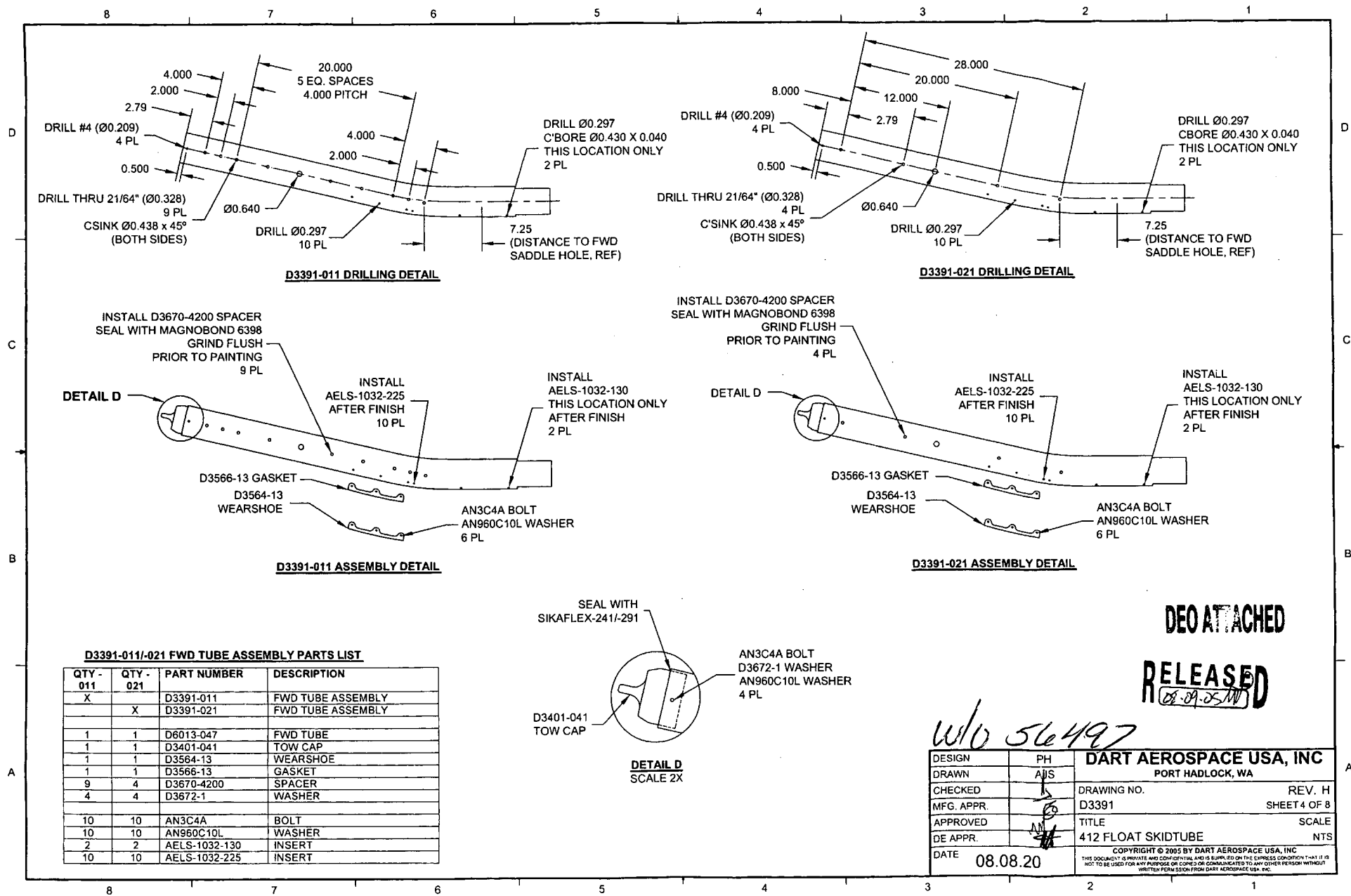
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DEO ATTACHED
 RELEASED
 08-07-25

W/O 56497

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

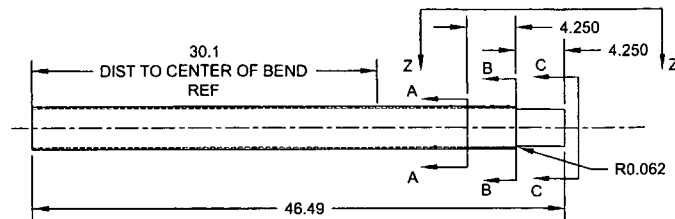
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

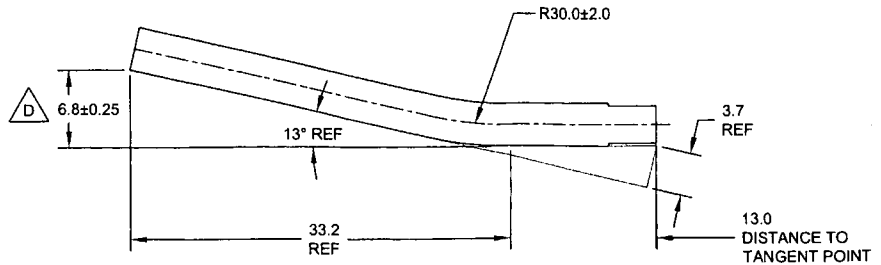
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

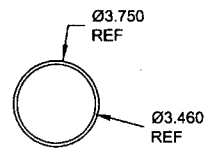
NOTE: Date & initial all entries



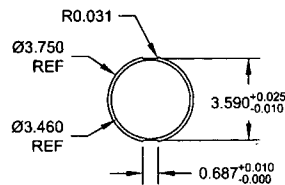
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



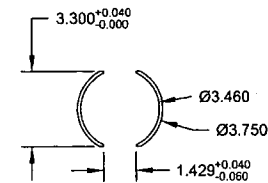
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



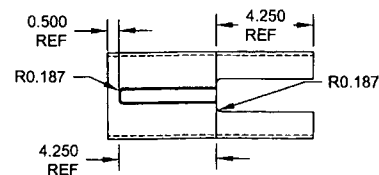
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

DEO ATTACHED
RELEASED
28 JAN 05 NW

W1056497

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

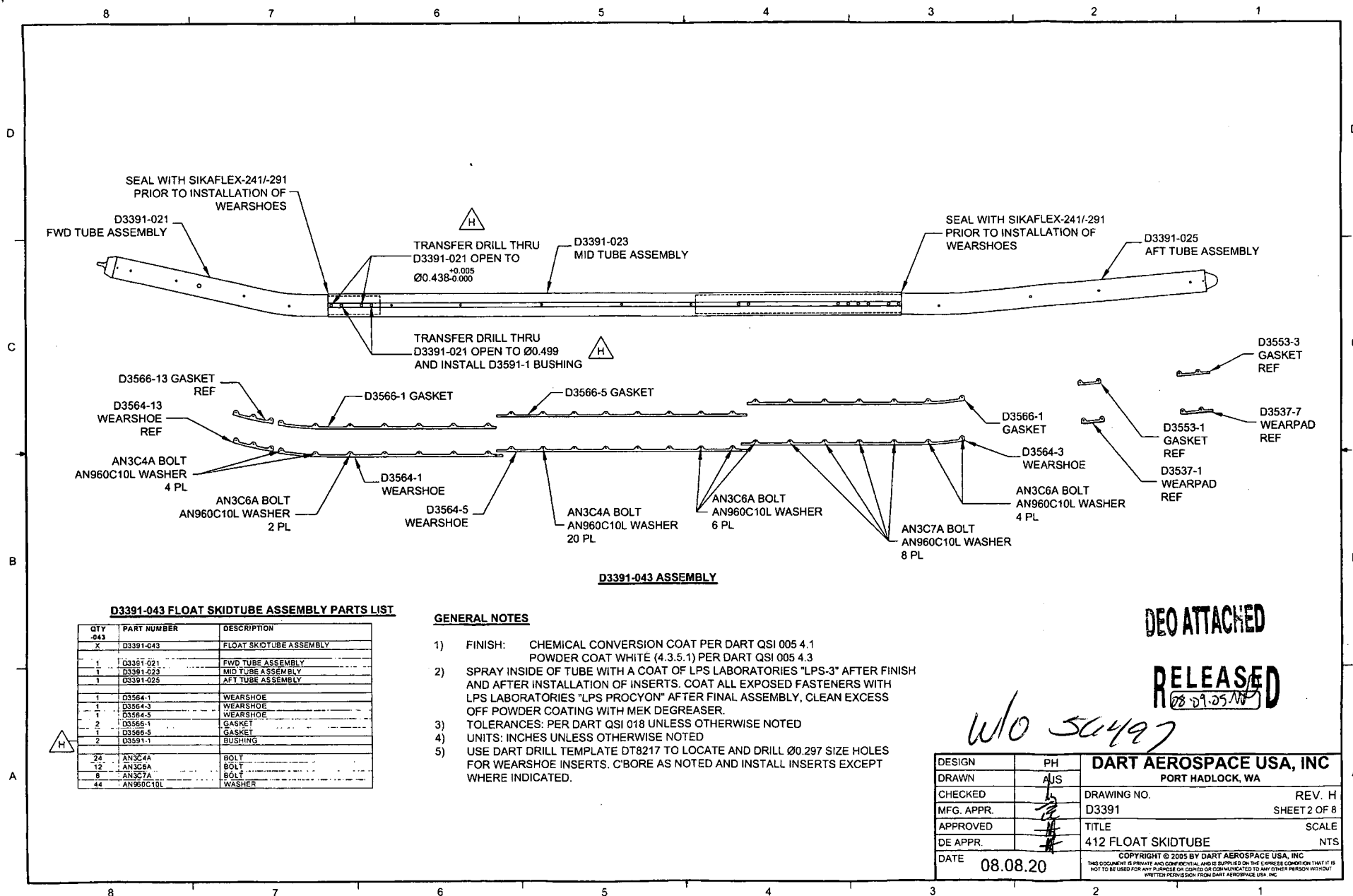
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ENGINEERING

~~SUBJECT TO AMENDMENT.~~

WORK ORDER

NO 56497

B/10-225



RELEASED
58-09-05 NW

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL. ADDED D03591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL. ADDED D03591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)		AJS	08.08.20
G	REPLACE NUTS WITH W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY		DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021		PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE		PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE		PH	08.01.23
C	LENGTHEN AFT EXTENSION		PH	05.09.27
B	DRAWING UPDATES		PH	05.06.10
A	NEW ISSUE		PH	05.02.07
REV		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA		
DRAWN				
CHECKED	PH	DRAWING NO. D3391 TITLE 412 FLOAT SKIDTUBE	REV. H	SHEET 1 OF 1 SCALE NT
MFG. APPR.	AJS			
APPROVED				
DE APPR.				
DATE		08.08.20 COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>		

Picklist Print

Page 4

February 25, 2010 10:47:46 AM

Work Order ID: 56497



Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 2/25/10

Required Date: 3/05/10

Comments: IPP A 05.09.13 New issue
IPP B 06.02.10 Dwg rev.D ecn 773
IPP C 06.05.02 Added inspections
IPP D 07.03.13 rev F dwg

KJ/JLM
EC
EC
EC

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No 255 Each 1,682.000 4.0000



Phenolic Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1182

39275

19

42329

5

47628

158

52505

1000

Main Warehouse

ST117

500

51674

500

AELS-1032-130 Purchased

No

* ?

255

Each

0.0000

2.0000



INSERT

AELS-1032-225 Purchased

No

* ?

255

Each

0.0000

10.0000



INSERT

x4 10/09/01

1114723 x2 10/09/01

1110768 x10 10/09/01

Picklist Print

February 25, 2010 10:47:46 AM

Page 3

Work Order ID: 56497



Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 2/25/10

Required Date: 3/05/10

Comments: IPP A 05.09.13 New issue
IPP B 06.02.10 Dwg rev.D ecn 773
IPP C 06.05.02 Added inspections
IPP D 07.03.13 rev F dwg

KJ/JLM
EC
EC
EC

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

Purchased

No

255

Each

388.0000

10.0000



washer

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

M115000

x10 JH 10/09/01

103585

100

Main Warehouse

ST

288

112116

128

112612

160

AN3C4A

Purchased

No

255

Each

1,033.000

10.0000



BOLT

* ?

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1033

M114941

*

x10 JH 10/09/01

112314

13

112720

12

112724

3

112829

1

112991

2

113121

64

113226

344

113644

394

113749

200

February 25, 2010 10:47:46 AM

Shop Packet Print

Page 3

Picklist Print

February 25, 2010 10:47:46 AM

Work Order ID: 56497

Parent Item: D3391-021

Parent Item Name: Fwd Tube Assembly


Start Date: 2/25/10

Required Date: 3/05/10

Comments: IPP A 05.09.13 New issue KJ/JLM
 IPP B 06.02.10 Dwg rev.D ecn 773 EC
 IPP C 06.05.02 Added inspections EC
 IPP D 07.03.13 rev F dwg EC

Start Qty: 1.00

Required Qty: 1.00

D3564-13 Manufactured No 255 Each 19.0000 1.0000


Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17

7

B59660

xl 41 10/09/01

51611

7

Main Warehouse

ST


12

45409

2

46495

10

D3566-13 Manufactured No 255 Each 79.0000 1.0000


Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

77

B59661

xl 41 10/09/01

53461

77

Main Warehouse

ST

2

45717

1

50265

1

Picklist Print

February 25, 2010 10:47:46 AM

Page 1

4

Work Order ID: 56497



Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 2/25/10

Required Date: 3/05/10

Comments: IPP A 05.09.13 New issue
IPP B 06.02.10 Dwg rev.D ecn 773
IPP C 06.05.02 Added inspections
IPP D 07.03.13 rev F dwg

KJ/JLM
EC
EC
EC

Start Qty: 1.00

Required Qty: 1.00

D6013-047



Skidtube Material

Manufactured No

100

Each

51.0000

1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

51

23935

3

26547

48

255

Each

83.0000

4.0000



BE 10/02/25

D3670-4-200



SPACER

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

83

48198

4

48269

79

255

Each

25.0000

1.0000



4/10/13

D3401-041



Tow Cap Assembly

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

25

36216

1

41931

1

46029

13

50316

10

XI 10/08/01



Work Order ID 56497


February 25, 2010 10:47:41 AM




Page 8

Item ID: D3391-021 Accept  Setup Start 
Revision ID: Stop 
Item Name: Fwd Tube Assembly
Start Date: 2/25/10 Start Qty: 1.00  Cust Item ID:
Required Date: 3/05/10 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
 QC	Memo	0.00							
Quality Control									

10/09/02 

MF
10-9-01

Work Order ID 56497

February 25, 2010 10:47:41 AM



Page 7

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 2/25/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

255

0.00



Skidtubes

0.00

Skidtubes

Memo

**** install D3591-1 spacer as per DSI9364 and wearplate and gasket as per DWG ****

27 JH 10/09/01 1 0

257

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

ml 10 09 01 (1)

260

Identify as per dwg & Stock Location: ^{W/O} 61474 0.00



Packaging

Memo

0.00

Packaging

ml 10 09 01 (1)

W/O: 56497		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/08/20	230.1	Pressure Wash & Realign AS Per PAR - 043	gl	10/08/20	1		

Part No: D3391-021 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56497

February 25, 2010 10:47:41 AM



Page 6

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 2/25/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC5- Inspect part completeness to step on W/O

0.00

8:10/03/04



QC

Memo

0.00

Quality Control

(40)

PTO 2)

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

m 114841

Memo

0.00

Powder Coating

START TIME: *8:40*
OVEN TEMPERATURE: *300°*
FINISH TIME: *9:10*

1 of 10-8-31

250

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> ml 10/09/01

1 of

Work Order ID 56497

February 25, 2010 10:47:41 AM



Page 5

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 2/25/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

DP

10-3-3

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1

H

10/3/3

220

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-instal spacers as per dwg D3391
A/R Magnabond 6398 batch: M112417
exp. date: 11/1/30
cure time 12hrs. as per QSI015
2- grind crossbolt flush
3-back drill crossbolt if necessary

M1013/3

Work Order ID 56497

February 25, 2010 10:47:41 AM



Page 4

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 2/25/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A")								
	2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step								
	3-Open tow cap holes to .208" as per Dwg D3391								
	4-Open Tow Ring hole to .640" as per Dwg D3391								
	5- open float bag holes 0.328" and counter sink as per dwg D3391								
	6-Deburr & Scribe Batch number Inside aft end.								
	7-Transfer drill D3391-021 with D3391-023								
190 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							

M 10/3/12

8/10/12

40



Work Order ID 56497

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Page 3

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 2/25/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

mk 10/02/28

1 0

Quality Control

170

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

S.P 10/03/02

Quality Control

Work Order ID 56497

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Page 2

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 2/25/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HAAS 1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA590 Rev. <u>AA</u> & Dwg D3391 Rev. <u>H</u> Identify as D3391-1 2-Deburr	0.00 0.00				<u>1</u>	<u>0</u>		
140 QC	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<u>1</u>	<u>0</u>		
150 Mill Conv	CONVENTIONAL MILLING MACHINE Memo Drill X1 Aft cap as per Dwg D3391 .1875" dia	0.00 0.00				<u>1</u>	<u>0</u>		

Work Order ID 56497

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Page 1

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 2/25/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

[Signature]

Date: 10-2-25 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H								
100		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	Cut extrusion to 46.52 +0.010 -0.020								
110		0.00							
	BENDING MACHINE - SKIDTUBES								
CNC Bend I	Memo	0.00							
CNC Delta 100 Bender	Bend as per Dwg D3391 Using Bend Prog 3391021								
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

(A)

BE 10/02/25

DP

10-2-25

*h = 6.750
C = 12.6°*

*8
10/02/26*